

Date: Tuesday, 4/25/2006 8:42:10 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JACK SADDLE		
Job Number	: 26814					
Estimate Number	: 11177					
P.O. Number	: N/A			Part Number	: D2281	
This Issue	: 4/25/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2281 REV G	
First Issue	: N/A		Type	: SMALL /MED FAB		
Previous Run	: 25132			Project Number	: N/A	
Written By	: See My Comment Below			Drawing Revision	: G	
Checked & Approved By	: J. Johnston 06.04.25			Material	: N/A	
Comment	Est Rev.A	Removed from 9 Digit	05-12-02	JLM	Due Date	5/20/2006
					Qty:	100
					Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: 1090 Email or Ship Dxf file to vendor Laser cut as per Dwg D2281 Material release note required.	<i>C:\J\06\04\25</i> <i>100</i>
2.0	D2281F	Jack Saddle	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Jack Saddle	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	<i>SL 06/05/19 98</i>
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	<i>J 06/05/10 08</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: Deburr.	<i>H-M 06/05/19 (99)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/06/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: JACK SADDLE

Job Number: 26814

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 06/06/05 99

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W521

CPL 06-06-06

9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/05 99

Job Completion



LL 06.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

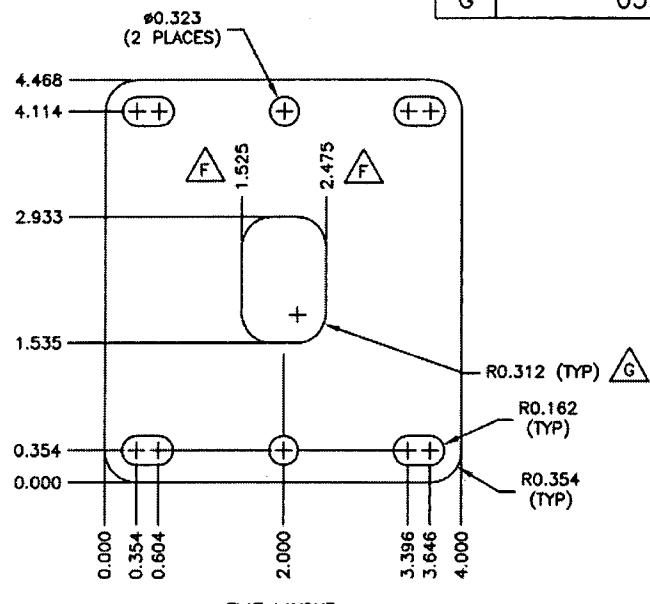
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

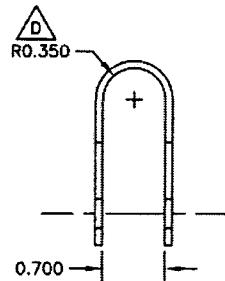
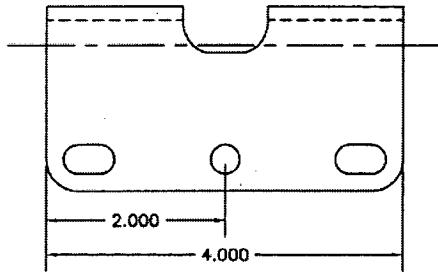


DESIGN BW	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ip</i>	APPROVED <i>WMS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2

RELEASED  
*AB*  
05/08/11



FLAT LAYOUT



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26814

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Shanxi Taiyang Stainless Steel CO.,LTD Member  
of Taiyuan Iron and Steel (Group) Co.,LTD  
NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China  
TEL: (0351)3013328 FAX: (0351)3017816  
http://www.tisco.com.cn  
E-mail: tgbxg@tisco.com.cn

**MILL TEST CERTIFICATE**

MATERIAL	AISI304 No.2B Finish	ASME SA240/SA480
SPECIFICATION	ASTM A240/A480	
L/C NO.		
CERTIFICATE NO.	20051187	
DATE OF ISSUE	11/11/2005	

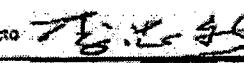
CUSTOMER: **OLBERT** CONTRACT NO.: **1187** DATA OF: **2005/11/20**

Product: **Melting furnace** Inspection stamp:  Mark of the Manufacturer: **Shanxi Taiyuan Stainless Steel Co.,Ltd**

COIL	E+VOD	Dimensions	Weight (kg)
NO.	Heat No.	Cell No.	Quantity
8.	4505286	SA9-49-1ZD	1
9	Y506019	SA9-485-1ZD	1
10	4505044	SA9-438-1ZY	1
11	4505274	SA9-450-1ZD	1
12	4505271	SA10-44-3ZJ	1
13	4505050	SA10-53-1ZJ	1
14	4505393	SA10-70-4ZY	1

Chemical Composition											
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4505286	0.060	0.470	1.400	0.017	0.003	18.170	8.020	0.010	0.010	0.010	0.055
Y506019	0.050	0.350	0.990	0.032	0.004	18.300	8.090	0.440	0.006	0.120	0.070
4505044	0.060	0.450	1.370	0.018	0.002	18.200	8.120	0.010	0.010	0.010	0.050
4505274	0.060	0.520	1.320	0.017	0.002	18.150	8.120	0.010	0.010	0.010	0.045
4505271	0.060	0.470	1.320	0.016	0.003	18.170	8.110	0.010	0.010	0.010	0.045
4505050	0.050	0.480	1.290	0.014	0.002	18.230	8.040	0.010	0.010	0.010	0.040
4505393	0.070	0.480	1.360	0.017	0.002	18.200	8.070	0.010	0.010	0.010	0.040

Test No.	Tensile Rm N/mm <sup>2</sup>	R <sub>p0.2</sub> Yield 0.2% N/mm <sup>2</sup>	R <sub>pt0.5</sub> Yield 0.5% N/mm <sup>2</sup>	Elongation A5%	Corrosion Time	Hardness		
						HRB	HV	HRC
4505286-T	635	282		53		84-83		
Y506019-T	650	266		53		88		
4505044-T	675	307		59		83-83		
4505274-T	690	299		56		86-85		
4505271-T	700	326		54			186-186	
4505050-T	695	297		57			190-188	
4505393-T	680	305		60		86-85		

Surface and dimensions controlled: 
Work Inspector: 

P60124PC001V 3042B .062X48 HT 4505271 4505050



New Zealand Steel Limited  
Glenbrook, 1626 Auckland  
Postal: Private Bag 92121, Auckland, New Zealand  
Telephones: (09) 375 0200 / 375 0111 Auckland  
(09) 235 8209 / 235 3634 Warkworth  
Fax (09) 375 0909

## TEST CERTIFICATE

Ref: 55124648

CUSTOMER		Wilksons		1251622MEO03												SPECIFICATION		ASTM A101 CS Type B						CERTIFICATE No			
CUSTOMER ORN		96-JIN-108														PRODUCT		HOT ROLLED PICKLED & OILED						PAGE		1 of 1	
MILL ORN		518691														DIMENSIONS		0.104" x 48" x 6ft						DATE		17 January 2006	
PACK NUMBER	(Sample) HEAT NO			CHEMICAL COMPOSITION PERCENT												MECHANICAL TESTS (TEST SPECIFICATION -											
		C	Si	Mn	x100												B	N2	CE(%)	BEND	YIELD	T.S.	WELONG	THICKNESS	(T)	LENGTH (mm)	
HP-997711-00	646664	6	1	20	9	19										x10000	x100	180°	Good							942	
HP-997712-00	646664	6	1	20	9	19													Good							961	
HP-997713-00	646846	5	TR	20	11	19													Good							955	
HP-997714-00	646846	5	TR	20	11	19													Good							955	
HP-997715-00	646664	6	1	20	9	19													Good							955	
HP-997716-00	646664	6	1	20	9	19													Good							955	
HP-997717-00	646846	5	TR	20	11	19													Good							958	
HP-997718-00	646846	5	TR	20	11	19													Good							958	
HP-997719-00	646846	5	TR	20	11	19													Good							958	
HP-997720-00	646846	5	TR	20	11	19													Good							958	
HP-997721-00	646846	5	TR	20	11	19													Good							958	
HP-997722-00	646846	5	TR	20	11	19													Good							958	

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=6mm	PLASTIC STRAIN RATIO (P) (A)=0 (B)=0.00 (C)=0.05 (D)=(0.06/245)/4	IMPACT TEST (A)=1.6mm x 10mm (B)=2.5mm x 10mm (C)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Ni+Nb)/15	(C)=C+Mn/6+S/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED / *Surish Misra*

OC METALLURGIST

